

Date: Thursday, 01/05/2008 11:57:00 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : AFT DOUBLER

Job Number : 38945

Estimate Number : 13278

P.O. Number :

This Issue : 01/05/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL / MED FAB

Previous Run : 38835

Part Number : D37031

Drawing Number : D3703 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 05/05/2008

Qty:

Um:

Each

Written By :

Checked & Approved By :

Comment : Est Rev:A 08-04-24 new issue DD verified by:EC

Additional Product

PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S063

6061-T6 .063 Sheet



Comment: Qty.: 0.5814 sf(s)/Unit Total : 2.9069 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 107387

IB 8-5-1

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3703

Dwg Rev: PRE L

Prog Rev: PRE L

****grain direction along 6.05****

2- Deburr if necessary

IB 8-5-1

(4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
PROVAL

2008-05-20

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3703

2008-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:57:00 AM
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Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



1
08.05.21

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Not required B

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required B

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

B 08.05.21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.21 Prototype only.

Job Completion



MF 08-06-13

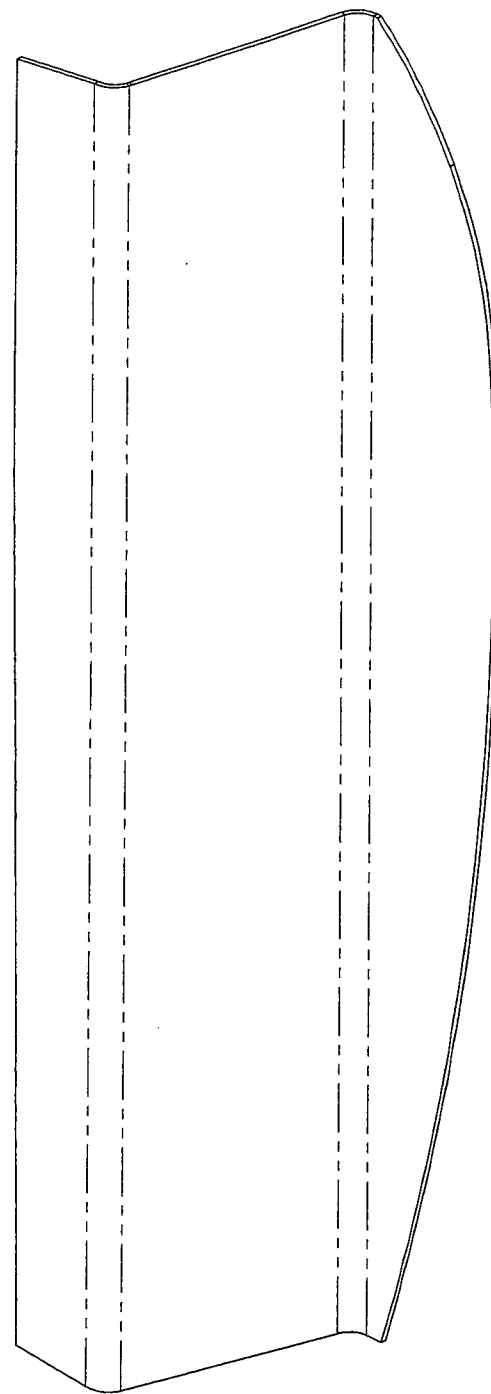
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

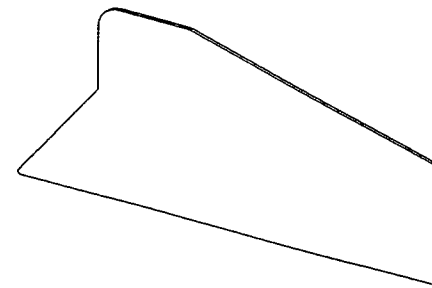
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

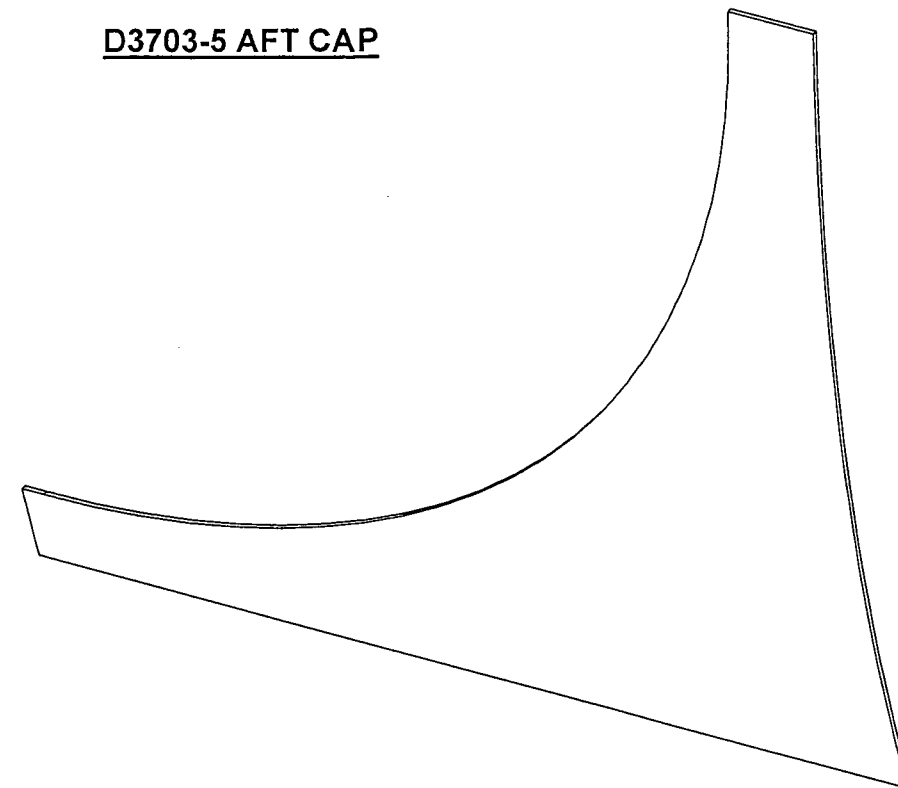
NOTE: Date & initial all entries



D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

NOTES:

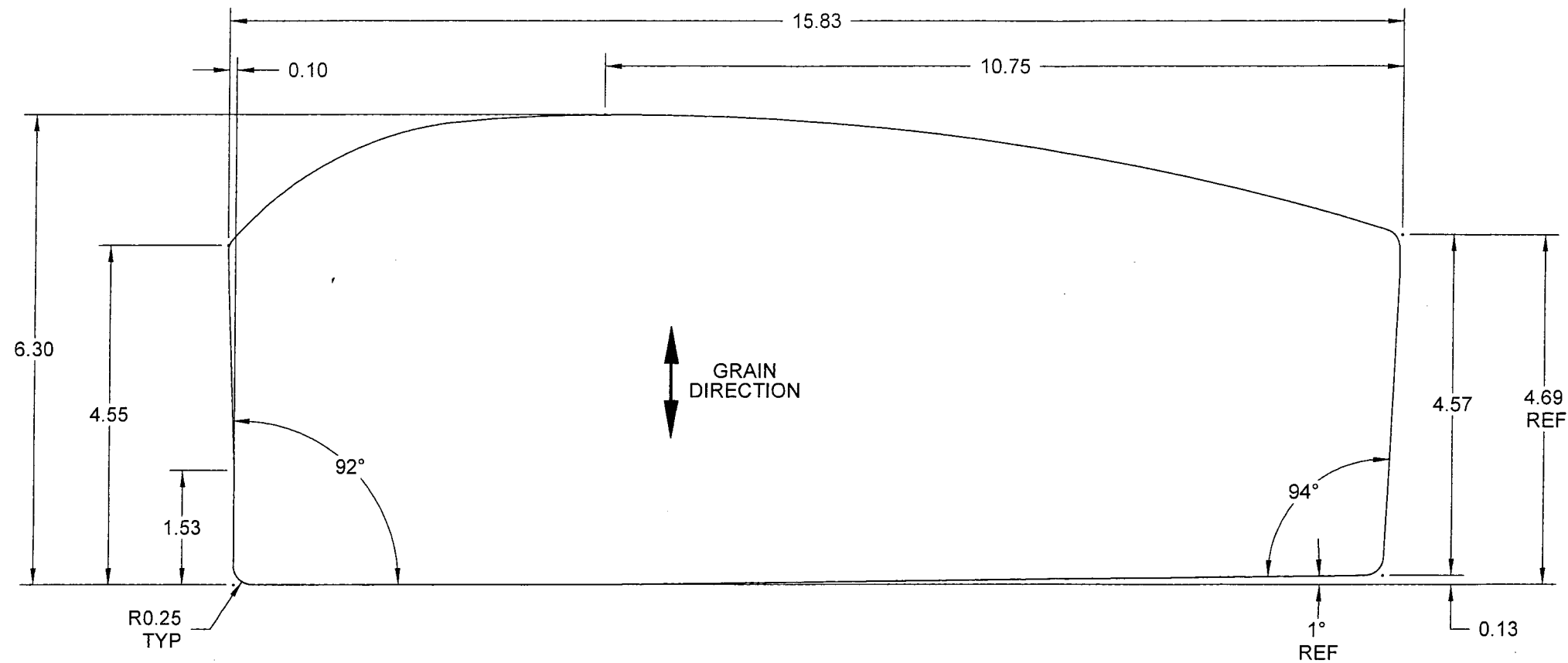
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38945

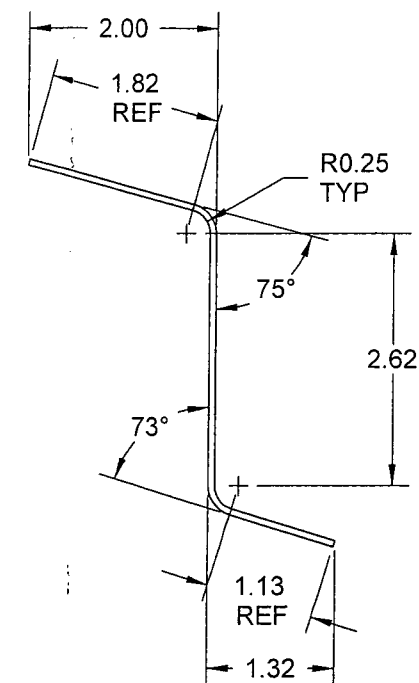
PROTOTYPE

PRELIMINARY ISSUE
08.04.30

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3703-1F AFT DOUBLER FLAT PATTERN



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38945

D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)

PROTOTYPE

PRELIMINARY ISSUE

08.04.30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	08.04.30	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NREBT : 03484/04

PAGE : 1/ 2

INSPECTION CERTIFICATE

Aleris
Europe

CUSTOMER : ALERIS ALUMINUM US SALES INC.

Aleris Aluminum Duffel BVBA
A. Stockhousen 87, 2570 Duffel - Belgium

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)
OUR ORDER NUMBER : 03484/04
DOCUMENT NUMBER : V/0080236963

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .063"
ARTICLE NO. :

08/3/12

COIL
NUMBER

CAST
NUMBER

CHEMICAL COMPOSITION (%)

	MIN	SI	FE	CU	MN	MG	CR	TI	ZN
	MAX	0,40		0,15		0,8	0,04		
		0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
004		0,62	0,4	0,19	0,07	1,0	0,15	0,03	0,05
005		0,68	0,4	0,20	0,08	1,0	0,17	0,02	0,03

OTHERS : EACH : MIN
TOTAL : MIN

0,05 MAX
0,15 MAX

MECHANICAL PROPERTIES

TEST-
NUMBER

(T) = TRANSVERSAL (L) = LONGITUDINAL
1 N/MM2 = 1 MPA = 0,1 HBAR 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /F = FRONT END /O = RANDOM SAMPLING

	MIN	RM	RP02	A
	MAX	KSI	KSI	%
		42	35	10
004	/A	50	42	13
004	/M	49	42	16
004	/V	50	41	13
005	/A	50	41	16
005	/M	50	41	13
005	/V	50	41	18

Aleris Aluminum Duffel BVBA

59983
24/4



Aleris Aluminum Duffel BVBA
A. Stockman 87, 2870 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER

004 STENCILLING : WEEK 17 / YEAR 2007
005 STENCILLING : WEEK 17 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS

A handwritten signature in black ink, appearing to read "X. Scheltjens", written over a horizontal line.

Aleris Aluminum Duffel BVBA